

# Work Order ID 110070

\*110070\*

Page 1

Item ID: D4034-041

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Aft Upper Rib Assembly

Stop

\*NS2\*

Start Date: 12/17/13 Start Qty: 4.00

\*4\*

3

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 13-12-19

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4034

C

100

Weld per dwg A/R S.S. rod Batch: B123823 0.00

\*100\*

Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib and grind weld flush as per dwg

(3x) CC 14-1-20

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

\*110\*

QC

Memo

0.00

Quality Control

PC 14.01.23

3

120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

Quality Control

PC 14.01.23

3

Work Order ID 110070

\*110070\*

Page 2

December-17-13 9:07:31 AM

Item ID: D4034-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Aft Upper Rib Assembly

Start Date: 12/17/13 Start Qty: 4.00

\*4\*

Required Date: 12/17/13 Req'd Qty: 4.00

\*4\*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WA04</u>	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

PC 14-01-23

3

ML5 14-01-24

① 14-01-23



December-17-13 9:07:30 AM

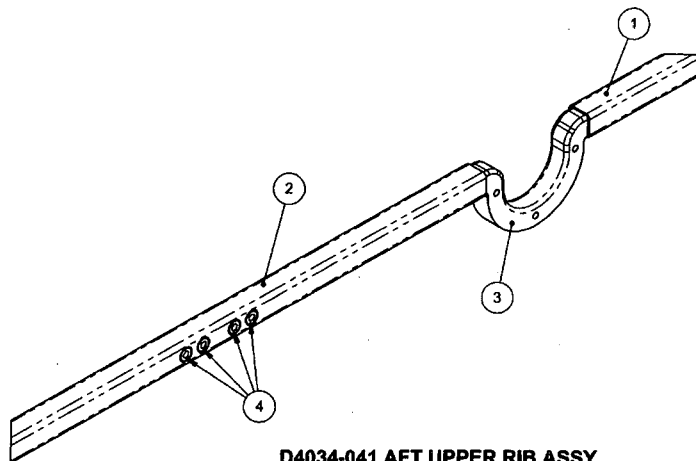
**Required Qty: 4.00**

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-1 Rib		Manufactured	No			100	Each	0.0000		4		CC 14-1-20	
D4034-3 Rib		Manufactured	No			100	Each	12.0000	1	4		CC 14-1-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		12							
				103361		8							
				103758		2							
				105079		2							
D4021-7 Hoop		Manufactured	No			100	Each	17.0000	1	4		CC 14-1-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		17							
				104309		10							
				105882		1							
				108059		6							
D4021-9 Bushing		Manufactured	No			100	Each	128.0000	4	16		CC 14-1-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		128							
				102482		4							
				106513		25							
				107634		97							
				99143		2							

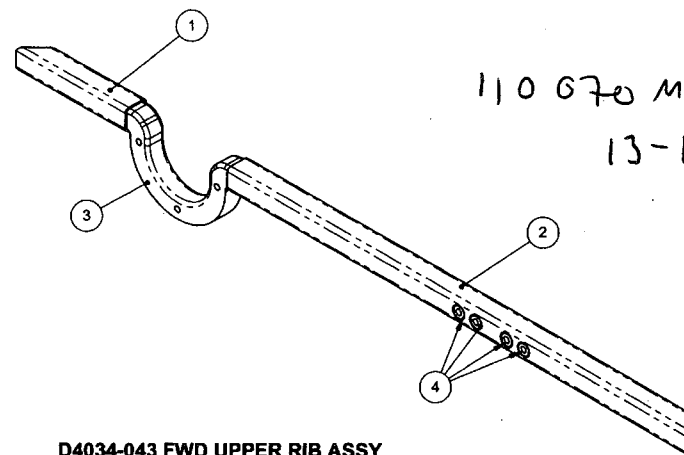


ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1	1	D4034-3	RIB
3	1	1	D4021-7	HOOP
4	4	4	D4021-9	BUSHING

△



**D4034-041 AFT UPPER RIB ASSY**



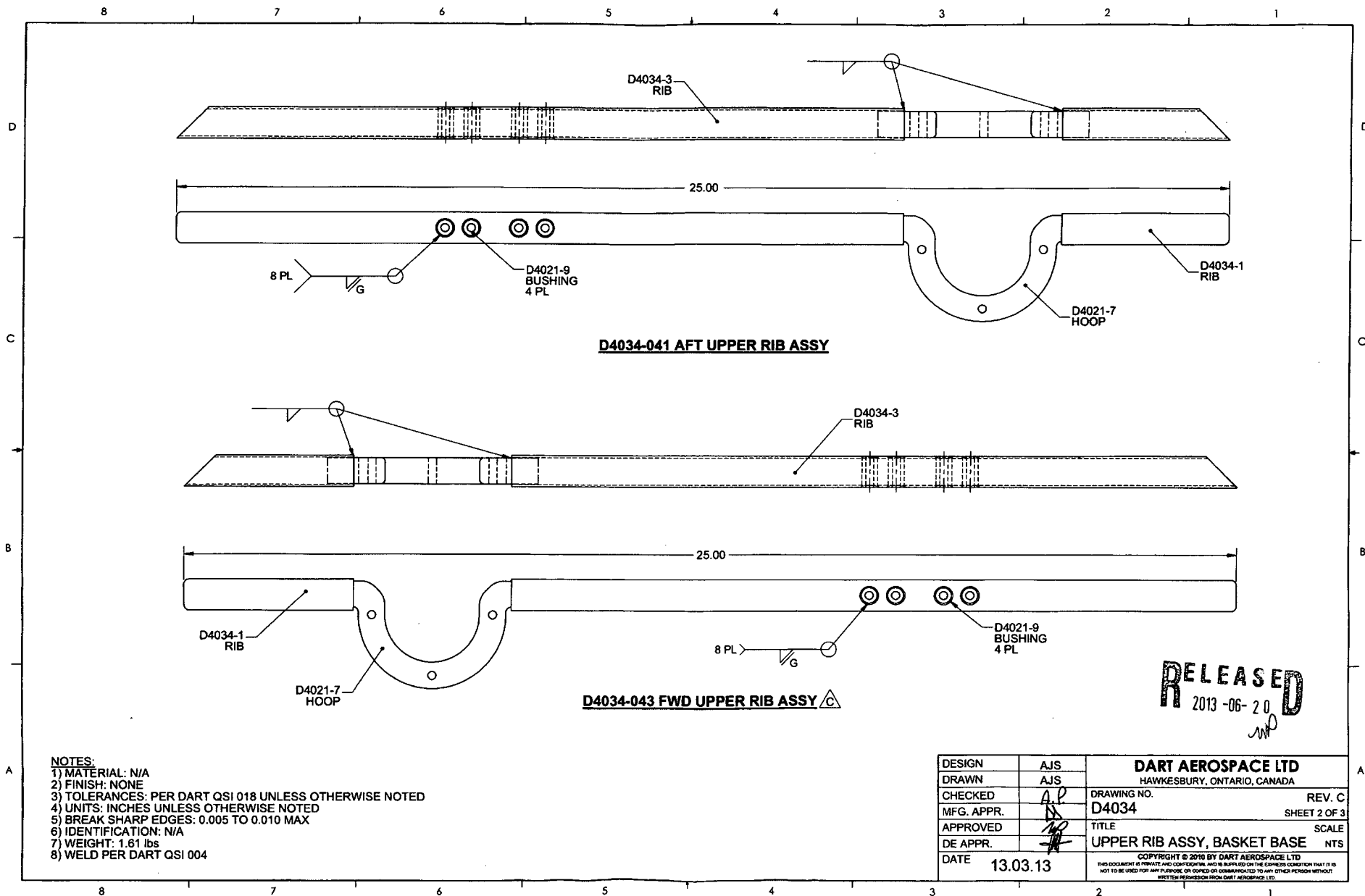
**D4034-043 FWD UPPER RIB ASSY**

110 070 MJS  
13-12-19

**RELEASED**  
R 2013-06-20  
MJS

C	-043 REDESIGNED AS MIRROR IMAGE OF -041. -5 DELETED. D2327-3 DELETED. REASON PROP ARM NO LONGER OFFERED.	AJS	13.03.13
B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	IS	D4034	SHEET 1 OF 3
APPROVED	14	TITLE	SCALE
DE APPR.	14	UPPER RIB ASSY, BASKET BASE	NTS
DATE	13.03.13	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

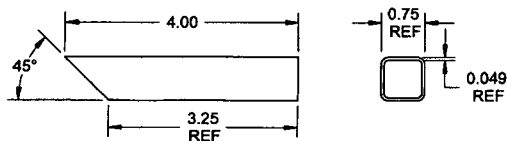




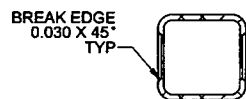
**RELEASED**  
 2013-06-20  
*[Signature]*



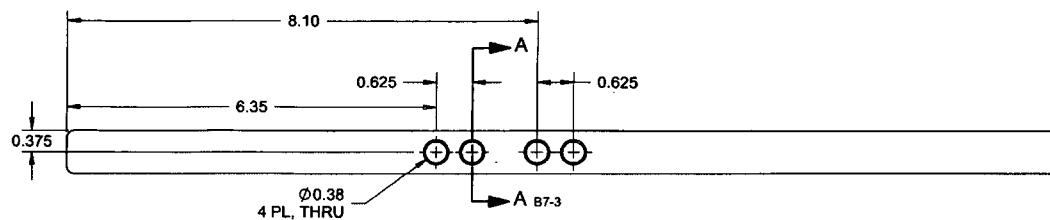




**D4034-1 RIB**



**SECTION A-A C3-3**



**D4034-3 RIB**

**RELEASED**  
2013-06-28

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs  
-3: 0.62 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	<b>D4034</b>	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	UPPER RIB ASSY, BASKET BASE	NTS
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